

Work Order ID 152112

Wednesday, October 19, 2016 3:29:07 PM

152112

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Item ID: PB67-43001-09 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Blade Fold Assembly Weldment
Start Date: 9/6/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 10/19/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: **DAS 21** Date: **OCT 20 2016** Tooling: Date: Run Start ***NR1***
QC: **9-89** Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
B67-43001-09	DE 21

100 Weld per dwg A/R Aluminum rod Batch: **134826**
Large Fab

100

Large Fab

Memo

0.10

Large Fab

1- Assemble parts on jig DT8814 and weld as per dwg PB67-43001

** Ensure no burn thru after welding in tube -235 and -229 only where bushing -
265 ***

DEC 19 2016**6PC**

110

QC9- Inspect visual per OSI004- Fusion Welds 0.00

110

QC

Memo

0.00

Quality Control

**DAS
18
9-89****1 16-12-20**

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DAS
9
7-8.9

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <i>MEZZ</i>	0.00				<i>1</i>		<i>JAN 05 2017</i>	<i>lpc</i>
150	Packaging								
Packaging	Memo	0.00							
160	QC21- Final Inspection - Work Order Release	0.00				<i>DAS</i>		<i>JAN 06 2017</i>	
160	QC					<i>21</i>			
Quality Control	Memo	0.02				<i>9-89</i>			
						<i>DAS</i>		<i>JAN 05 2017</i>	
						<i>21</i>			
						<i>9-89</i>			

Picklist Print

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152112

Parent Item: PB67-43001-09

PR67-43001-09

Parent Item Name: Aft Blade Fold Assembly Weldment

Start Date: 9/6/2016

Required Date: 10/19/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-06-25 new issue DD verified by:ec IPP RevB
10.09.24 per revC dwg EC verified by:DD IPP REV:C 14.12.15
AS PER DWG REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

PB67-43001-203W		Manufactured	No			100	Each	2.0000	1	1			
-----------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

PR67-43001-203W

Square Tube Weldment

Location

Loc Qty

Loc Code

MEZZ

2

139208

2

PB67-43001-229W		Manufactured	No			100	Each	0.0000	1	1			
-----------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

PR67-43001-229W

Outer Tube Weldment

PB67-43001-239W		Manufactured	No			100	Each	0.0000	1	1			
-----------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

PR67-43001-239W

Square Tube Weldment

PB67-43001-201		Manufactured	No			100	Each	1.0000	2	2			
----------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

PR67-43001-201

Square Tube

Location

Loc Qty

Loc Code

Mezz2

1

139209

1

PB67-43001-209		Manufactured	No			100	Each	0.0000	1	1			
----------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

PR67-43001-209

Square Tube

1x 152143 MF 16-12-15

1x 153579 MF 16-12-15

152081 MF 16-12-15

152073 MF 16-12-07

152081 MF 16-12-11

Picklist Print

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Parent Item: PB67-43001-09

PR67-43001-09

Parent Item Name: Aft Blade Fold Assembly Weldment

Start Date: 9/6/2016

Required Date: 10/19/2016

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-211 Manufactured No

100 Each 6.0000 6 6

PR67-43001-211

Square Tube

Location

Loc Qty

Loc Code

Mezz2

6

139201

6

152092 MF 16-12-07

PB67-43001-213 Manufactured No

100 Each 3.0000 2 2

PR67-43001-213

Flanged Hook

Location

Loc Qty

Loc Code

Mezz2

3

112764

1

139200

2

MF 16-12-07

PB67-43001-235 Manufactured No

100 Each 0.0000 1 1

PR67-43001-235

Outer Tube

153528 MF 16-12-05

PB67-43001-243 Manufactured No

100 Each 2.0000 1 1

PR67-43001-243

Tube Handle Extension

Location

Loc Qty

Loc Code

Mezz2

2

139196

2

MF 16-12-07

PB67-43001-277 Manufactured No

100 Each 4.0000 1 1

PR67-43001-277

Contoured Male Eye

Location

Loc Qty

Loc Code

Mezz2

4

148792

4

MF 16-12-07

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Shop Packet Print

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Picklist Print

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Parent Item: PB67-43001-09

PR67-43001-09

Parent Item Name: Aft Blade Fold Assembly Weldment

Start Date: 9/6/2016

Required Date: 10/19/2016

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-311

Manufactured No

100

Each

2.0000

2

2

PR67-43001-311

Restraint

Location

Loc Qty

Loc Code

Mezz

1

90935

1

Mezz2

1

139192

1

152145 MF
10-12-07

D3440-9

Manufactured No

100

Each

3.0000

1

1

D3440-9

Tube Detent Clip Base (Supersedes B67-43001-241)

Location

Loc Qty

Loc Code

Mezz2

3

139210

3

MF 10-12-07

D3440-13

Manufactured No

100

Each

3.0000

1

1

D3440-13

Bracket (Supersedes B67-43001-273)

Location

Loc Qty

Loc Code

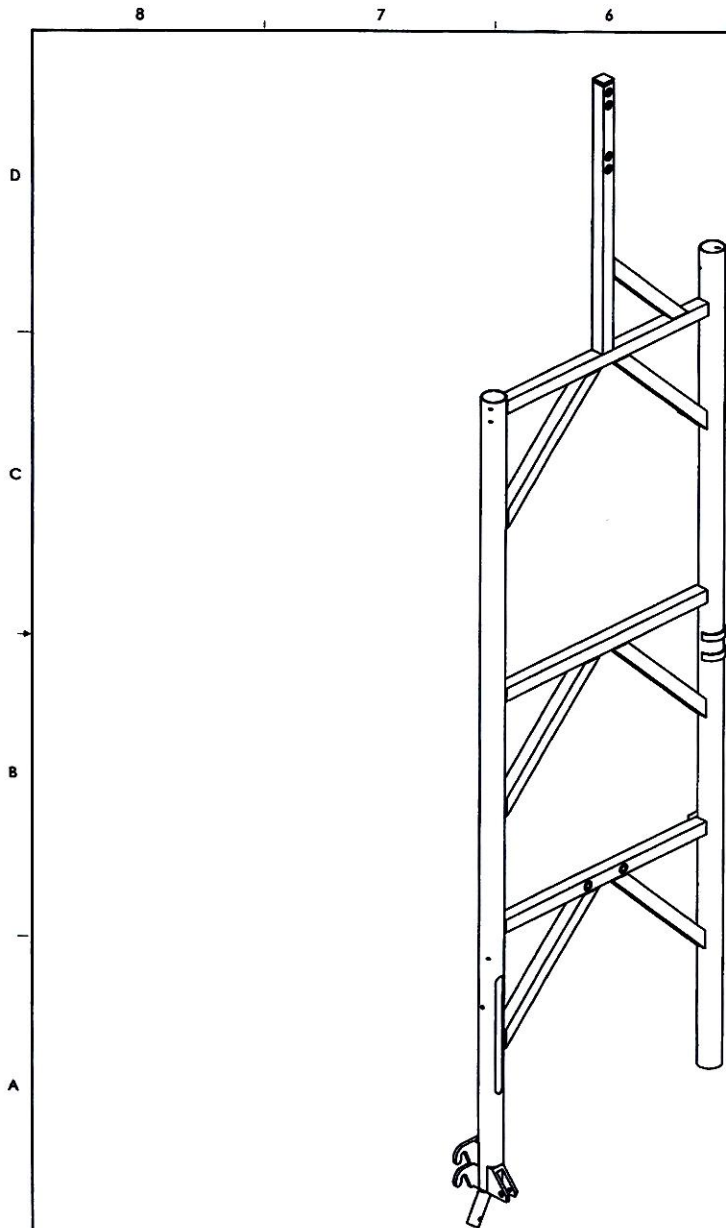
Mezz2

3

139211

3

MF 10-12-07



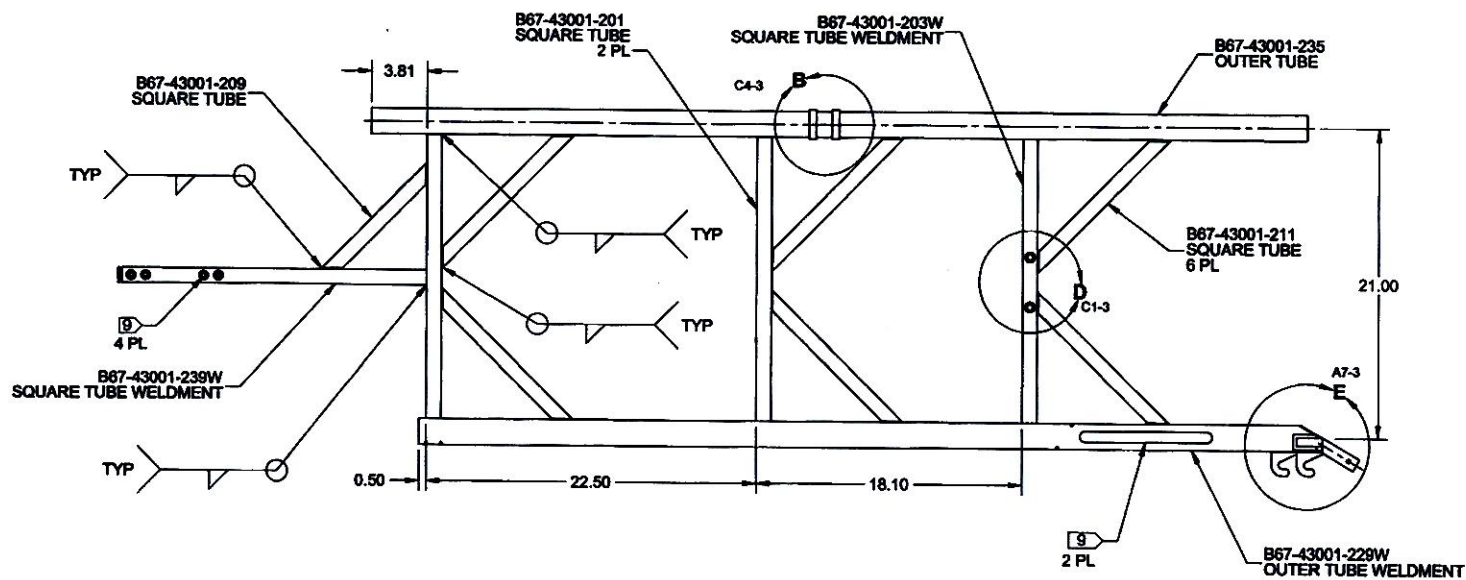
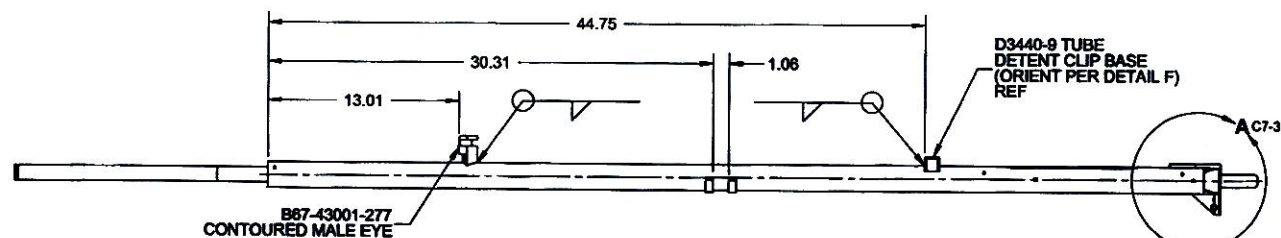
ITEM	QTY .09	P/N	DESCRIPTION
	X	B67-43001-09	AFT BLADE FOLD ASSEMBLY WELDMENT
1	2	B67-43001-201	SQUARE TUBE
2	1	B67-43001-203W	SQUARE TUBE WELDMENT
3	1	B67-43001-209	SQUARE TUBE
4	6	B67-43001-211	SQUARE TUBE
5	2	B67-43001-213	FLANGED HOOK
6	1	B67-43001-229W	OUTER TUBE WELDMENT
7	1	B67-43001-235	OUTER TUBE
8	1	B67-43001-239W	SQUARE TUBE WELDMENT
9	1	B67-43001-243	TUBE HANDLE EXTENSION
10	1	B67-43001-277	CONTOURED MALE EYE
11	2	B67-43001-311	RESTRAINT
12	1	D3440-9	TUBE DETENT CLIP BASE
13	1	D3440-13	FLANGE HOOK

UNF
#152112
16-11-23

E	REMOVE MASKING INSIDE HOOK AREA ON B67-43001-213 (ZNA7-3) VERIFIED MATERIAL SPECIFICATIONS: WEIGHT AFFECTED (ZNA8-2) REASON: PAR15-437	SAD	16.10.18
D	REVISE BOM AND ANNOTATIONS TO INCORPORATE -203W/-229W/-239W WELDMENTS. DELETE DETAIL C (SH 2, 3); REASON: TO FACILITATE MANUFACTURING	DB	14.07.24
C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 4 OF PREMIER AVIATION DRAWING #B67-43001 REASON: SEE PAR109-011	MB	10.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	MB	DRAWING NO.	REV. E
MFG. APPR.	DD	B67-43001-09	SHEET 1 OF 3
APPROVED	WM	TITLE	SCALE
DE APPR.	N/A	AFT BLADE FOLD ASSY WELDMENT	NTS
DATE	16.10.18	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. NO PART OF THIS DOCUMENT IS TO BE REPRODUCED OR COPIED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

RELEASED
2016-11-09
EWK-655

APPROVED



B67-43001-09 AFT BLADE FOLD ASSY WELDMENT

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT "GREEN SANDTEX" (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 11.40 lbs
- 8) WELDING: PER QSI 004
- 9) MASKING: ALL OPENINGS AND INDICATED AREAS PRIOR TO POWDER COATING

RELEASED
2016-11-09

APPROVED

DESIGN	RW	DART AEROSPACE LTD	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. E
MFG. APPR.	DD	B67-43001-09	SHEET 2 OF 3
APPROVED	WM	TITLE	SCALE
DE APPR.	N/A	AFT BLADE FOLD ASSY WELDMENT	NTS
DATE	16.10.18	COPYRIGHT © 1996 BY DART AEROSPACE LTD	

MATE WITH TOP SURFACE OF
LOWER HOOK AND ALIGN WITH
CENTERLINE OF OUTER TUBE

ALIGN WITH BOTTOM
EDGE OF END CAP AND
CENTERLINE OF OUTER TUBE

ALIGN WITH CENTERLINE
OF OUTER TUBE AND FLUSH
WITH ANGLED CUT

B67-43001-243 [9]
TUBE HANDLE EXTENSION
REF

ALIGN WITH CENTERLINE OF
OUTER TUBE AND TO BOTTOM
SURFACE OF END CAP

D3440-13
BRACKET

DETAIL A D3-2
SCALE 4X

B67-43001-229W
OUTER TUBE WELDMENT
REF

MASK INSIDE SURFACES
OF BRACKET PRIOR TO
POWDER COATING

B67-43001-243 [9]
TUBE HANDLE EXTENSION

B67-43001-213
FLANGED HOOK
2 PL

DETAIL E B3-2
SCALE 4X

B67-43001-311
RESTRAINT
2 PL

MASK ALL AROUND TUBE
PRIOR TO POWDER COATING

B67-43001-235
OUTER TUBE
REF

DETAIL B C5-2
SCALE 4X

B67-43001-203W
SQUARE TUBE WELDMENT
REF

B67-43001-211
SQUARE TUBE
REF

[9]
2 PL

DETAIL D B4-2
SCALE 4X

[9] MASK INSIDE SURFACE AND
HOLE (NOT SHOWN) OF
CONTOURED MALE EYE
PRIOR TO POWDER COATING

D3440-9 TUBE DETENT CLIP BASE [9]
MASK THREADED HOLE (NOT SHOWN)
PRIOR TO POWDER COATING

DETAIL F C2-2
SCALE 4X

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2016-11-09

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DESIGN	RW	DART AEROSPACE LTD	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. E
MFG. APPR.	DD	B67-43001-09	SHEET 3 OF 3
APPROVED	WM	TITLE	SCALE
DE APPR.	N/A	AFT BLADE FOLD ASSY WELDMENT	NTS
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